



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3251-041
Job Sheet 169519



17

Part No: D3251-041

Job Qty: 6 ea

Part Name: Centre Divider



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Rev: A
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Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	12/28/17	12/28/17	0.00	0.00	Start Up Waterjet		SC 12/01/21
100	Waterjet	6 pcs	12/28/17	12/28/17	0.00	2.08	Waterjet1		SC 12/01/21
110	QC	6 pcs	12/28/17	12/28/17	0.00	0.00	QC2 Waterjet-1		SC 12/01/21
120	QC	6 pcs	12/28/17	12/28/17	0.00	0.00	QC8-2		38
130	Small Fab	6 pcs	12/28/17	12/28/17	0.25	1.42	Small Fab-3		9-88 DAS 53
140	QC	6 pcs	12/28/17	12/28/17	0.00	0.00	QC5		38
150	HandFinish	6 pcs	12/28/17	12/28/17	0.00	0.74	HandFinish1		12-02-08 8
160	QC	6 pcs	12/28/17	12/28/17	0.00	0.00	QC3		38
170	Small Fab	6 pcs	12/28/17	12/28/17	0.00	1.42	Small Fab-3		38 DAS
180	QC	6 pcs	12/28/17	12/28/17	0.00	0.00	QC5		38
190	Powdercoat	6 pcs	12/29/17	12/29/17	0.00	0.43	Powdercoat4		BR 12-08-21
200	QC	6 pcs	12/29/17	12/29/17	0.00	0.00	QC3		38
210	Packaging	6 pcs	12/29/17	12/29/17	0.00	0.00	Packaging3-1		ST248 6 FEB 22 2018
220	QC21-SA	6 Ea	12/29/17	12/29/17	0.00	0.00	QC21		21 9-88 FEB 22 2018

Part Op 100 - 1-Cut as per Dwg D3251

Descriptions: 130 - Bend as per dwg D3251

170 - Assemble as per dwg D3251

190 - START TIME:

1.55 00:11:320 FINISH: 2:05

M138300

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	20	261	0	0
170-Small Fab	D3248-1 5023931 12x	12	4	0	0
	MS20470AD4-5	108	2,908	0	0
	5024837 FM136851-2				

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Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____						MRB (QSI042) Approval	
Description Work Order Deviation				Disposition						Completed By	
				Start up Operation Job No: 169519 01/21/18 Change No: Operation: Revision: Original Serial #: S034037 D3251-041 PART NO: Operation: Revision: Original Serial #: S034037 D3251-041 Centre Divider S034037 DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com						Director	
										Inspector	
										ed Wrong	
										Dimensions	
Root Cause				Pressure/F Bending Centre Nc Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter						Under tolerance Incorrect Lost/Missing Moved wing ish isread Turning Sequence	
Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐						Misaligned/off center ☐ Fit/Function ☐ Misaligned/off center ☐	
OTHER : _____											

DART AEROSPACE LTD		Work Order:	169519
Description: Center Divider (Dual Battery Rack)		Part Number:	D3251-1
Inspection Dwg: D3251	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.567	+/-0.010	21.569			VLC-02	
1.250	+/-0.010	1.252			Tape	
5.16	+/-0.030	5.168				
1.079	+/-0.010	1.078				
R0.19	+/-0.030	R0.19				
4.15	+/-0.030	4.159				
2.75	+/-0.030	2.750				
0.300	+/-0.010	0.301				
3.71	+/-0.030	3.72				
1.250	+/-0.010	1.251				
2.97	+/-0.030	2.978				
10.81	+/-0.030	10.815				
9.90	+/-0.030	9.904				
18.595	+/-0.010	18.596				
0.983	+/-0.010	0.986				
Ø0.257	+0.005/-0.000	Ø0.258				
23.289	+/-0.010	23.290				
11.000	+/-0.010	11.000				
Ø0.128	+0.005/-0.000	Ø0.130				
5.403	+/-0.010	5.405				
0.987	+/-0.010	0.988				
11.77	+/-0.030	11.779				
4.499	+/-0.010	4.499				
1.375	+/-0.010	1.376				
2.750	+/-0.010	2.752				
Ø1.500	+0.005/-0.000	Ø1.501				
Ø0.501	+0.005/-0.000	Ø0.502				
21.056	+/-0.010	21.057				
18.93	+/-0.030	18.94				
Ø0.125	+0.005/-0.000	Ø0.125				
Ø0.098	+0.005/-0.000	Ø0.100				
R0.30	+/-0.030	R0.30				
0.300	+/-0.010	0.301				
0.063	+/-0.010	0.063				
Grain along 21.056	N/A	OK				

Measured by:	SC	Audited by:	JAS	Prototype Approval:	N/A
Date:	18/01/21	Date:	38 9-88 FEB 07 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	